

Date: Tuesday, 02/12/2008 10:02:17 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 02.750 SUPPORT (407AFT)
Job Number : 43881	
Estimate Number : 11059	
P.O. Number :	Part Number : D28941
This Issue : 02/12/2008 S.O. No. :	Drawing Number : D2894 UNDER REVIEW <i>E 08.12.02</i>
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 38126	Material :
Written By :	Due Date : 09/12/2008 Qty: <i>18/20</i> Um: Each
Checked & Approved By : <i>JUD 08.12.02</i>	
Comment : Est: B 02.11.26 Added mask hole KJ Est Rev: C ECN 993 07-11-07 DD verified by: EC est D 08.03.19 Re-format EC verified by DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DSK079	D2894-1 TURNING DETAIL
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Comment: Qty.: 0.5000 Each(s)/Unit Total: 10.0000 Each(s)
 D2894-1 TURNING DETAIL
 Batch: *B 38132* *JIT 08/12/11*

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS
 Machine as per Folio FA253
 Tumble & Deburr

J.L. / DJP 08/12/11

3.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

J.L. / DJP 08/12/11

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.F. 08/12/15 (18)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Mask primed area and 0.500" hole prior to paint as per dwg D2894

M. 08/12/15 (18)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 02/12/2008 10:02:17 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 02.750 SUPPORT (407AFT)

Job Number: 43881

Part Number: D28941

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M 109152



(18X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:40
4:00
4:10

M-H 08/12/15

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



ml 08 12 16

(18)



Comment: INSPECT POWDER COAT

8.0

SPRAY PAINTING

SPRAY PAINTING



Comment: HAND FINISHING RESOURCE #1

Mask and prime inside surface as per dwg D2894 per Dart QSI 005 4.2

BT 08-12-18 (18)

9.0

QC14

INSPECT SPRAY PAINT



ml 08 12 18



(18)

Comment: INSPECT SPRAY PAINT

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: X-tube

ml 08 12 18

(18)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



08/12/22

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-12-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 43881
Description: Ø2.750 Support		Part Number: D2894-1
Inspection Dwg: D2894	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.454	0.474		.462	0.460	0.460	0.460	0.461
AB	3.062	3.082		3.072	3.072	3.072	3.072	3.072
AC	0.053	0.073		0.063	0.063	0.063	0.063	0.060
AD	1.766	1.786		1.776	1.777	1.778	1.778	1.777
AE	0.020	0.040		.035	0.035	0.035	0.035	0.035
AF	0.260	0.267		.260	.260	0.260	.260	.260
AG	0.170	0.190		.178	0.180	0.180	0.180	0.180
AH	0.150	0.170		.158	0.160	0.160	0.160	0.160
AI	1.990	2.010		1.998	2.000	1.995	2.002	2.002
AJ	0.240	0.260		.250	0.250	0.250	0.250	0.250
AK	1.880	1.900		1.895	1.898	1.900	1.893	1.892
AL	0.500	0.505		.502	0.502	0.504	0.504	0.502
AM	0.188	0.194		.191	0.191	.191	.191	.191
AN	0.926	0.946						

Ensure that Ø0.500" bore is perpendicular to 1.389" bore within 0.003"

AN	±0.005	Accept/Reject	0.001	0.001	0.005	0.001	0.001
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Measured by: J.L./DIP Date: 08/12/11

Audited by: J.F. Date: 08/12/15

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	06.03.08	DT8708 added to dimension AM	KJ/JLM	
C	06.11.22	Note added to HAAS section	KJ/JLM	
D	08.04.22	Reformat; Dwg Rev updated	KJ/DD	
E	08.11.25	Dimensions updated per Dwg Rev. D	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 43881
Description: Ø2.750 Support		Part Number: D2894-1
Inspection Dwg: D2894	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6	7	8	9	10
HAAS Section								
AA	0.454	0.474		0.463	0.464	0.464	0.464	0.460
AB	3.062	3.082		3.072	3.072	3.072	3.072	3.072
AC	0.053	0.073		0.060	0.060	0.060	0.060	0.060
AD	1.766	1.786		1.778	1.7775	1.777	1.777	1.778
AE	0.020	0.040		0.030	0.030	0.030	0.030	0.030
AF	0.260	0.267		0.260	0.260	0.260	0.260	0.260
AG	0.170	0.190		0.180	0.180	0.180	0.180	0.180
AH	0.150	0.170		0.160	0.155	0.155	0.155	0.155
AI	1.990	2.010		2.009	2.000	1.997	2.004	2.000
AJ	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AK	1.880	1.900		1.898	1.895	1.897	1.899	1.894
AL	0.500	0.505		0.502	0.502	0.502	0.502	0.502
AM	0.188	0.194		0.192	0.192	0.192	0.192	0.192
AN	0.920	0.940						
AN	+0.005	-0.005		0.0005	0.000	0.0005	0.0015	0.001
Ensure that Ø0.500" bore is perpendicular to 1.389" bore within 0.003"								
Accept/Reject								

Measured by: JTP	Date: 08/12/12
Audited by: J.F.	Date: 08/12/15
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	06.03.08	DT8708 added to dimension AM	KJ/JLM	
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E	08.11.25	Dimensions updated per Dwg Rev. D	KJ/JLM	

DART AEROSPACE LTD		Work Order: 43881
Description: Ø2.750 Support		Part Number: D2894-1
Inspection Dwg: D2894	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.454	0.474		0.460	0.462	0.460	0.462	0.459
AB	3.062	3.082		3.072	3.072	3.072	3.072	3.072
AC	0.053	0.073		0.060	0.060	0.060	0.060	
AD	1.766	1.786		1.779	1.779	1.779	1.779	1.777
AE	0.020	0.040		0.030	0.030	0.030	0.030	0.030
AF	0.260	0.267		0.260	0.260	0.260	0.260	0.260
AG	0.170	0.190		0.180	0.180	0.180	0.180	0.180
AH	0.150	0.170		0.160	0.160	0.160	0.160	0.160
AI	1.990	2.010		2.002	1.998	1.996	1.999	2.006
AJ	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AK	1.880	1.900		1.890	1.895	1.896	1.894	1.893
AL	0.500	0.505		0.502	0.502	0.502	0.502	0.502
AM	0.188	0.194		0.192	0.192	0.192	0.192	0.192
AN	0.926	0.946						
AN	+ 0.005	- 0.005		0.0005	0.0005	0.0000	0.0005	0.0000
Ensure that Ø0.500" bore is perpendicular to 1.389" bore within 0.003"								
Accept/Reject								

Measured by: JTP	Date: 08/12/12
Audited by: J.F.	Date: 08/12/15
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
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DART AEROSPACE LTD		Work Order:	43881
Description: Ø2.750 Support		Part Number:	D2894-1
Inspection Dwg: D2894	Rev: D	Page 1 of 1	

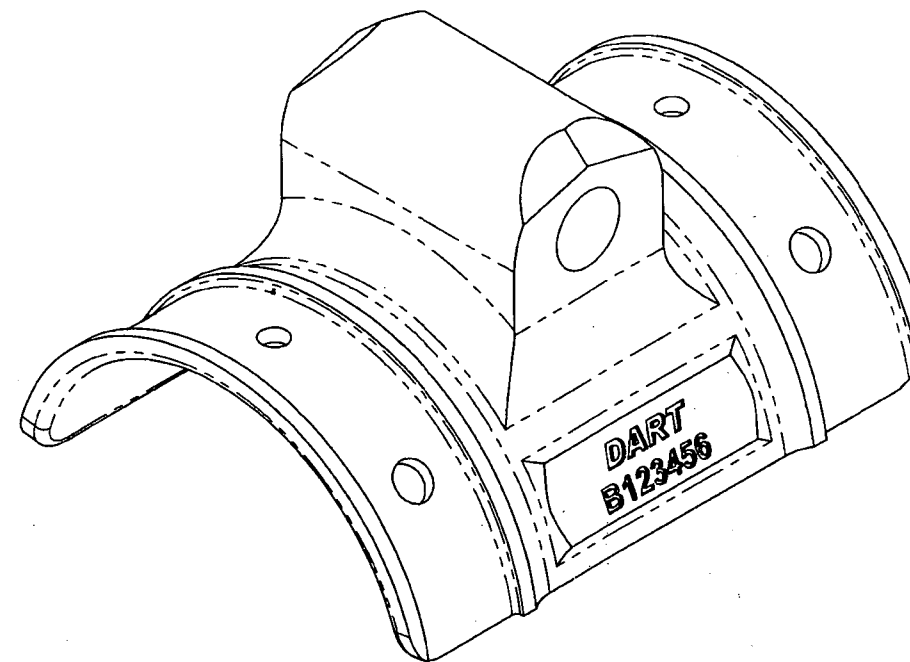
FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	20
HAAS Section								
AA	0.454	0.474		0.460	-462	-462		
AB	3.062	3.082		3.072	3.072	3.072		
AC	0.053	0.073		0.063	0.063	0.063		
AD	1.766	1.786		1.776	1.777	1.777		
AE	0.020	0.040		0.030	0.030	0.030		
AF	0.260	0.267		0.260	-260	-260		
AG	0.170	0.190		0.180	-180	-180		
AH	0.150	0.170		0.160	-160	-160		
AI	1.990	2.010		2.004	2.000	1.997		
AJ	0.240	0.260		0.250	-250	-250		
AK	1.880	1.900		1.875	1.887	1.885		
AL	0.500	0.505		0.502	502	502		
AM	0.188	0.194		0.192	-192	-192		
AN	0.926	0.946						
AN	+0.005	-0.005		0.001	-001	-0015		
Ensure that Ø0.500" bore is perpendicular to 1.389" bore within 0.003"								
Accept/Reject								

Measured by:	DJP/ J.L	Date:	08/12/14
Audited by:	J.F.	Date:	08/12/15
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	06.03.08	DT8708 added to dimension AM	KJ/JLM	
C	06.11.22	Note added to HAAS section	KJ/JLM	
D	08.04.22	Reformat; Dwg Rev updated	KJ/DD	
E	08.11.25	Dimensions updated per Dwg Rev. D	KJ/JLM	



D2894-1 Ø2.750 SUPPORT

NOTES:

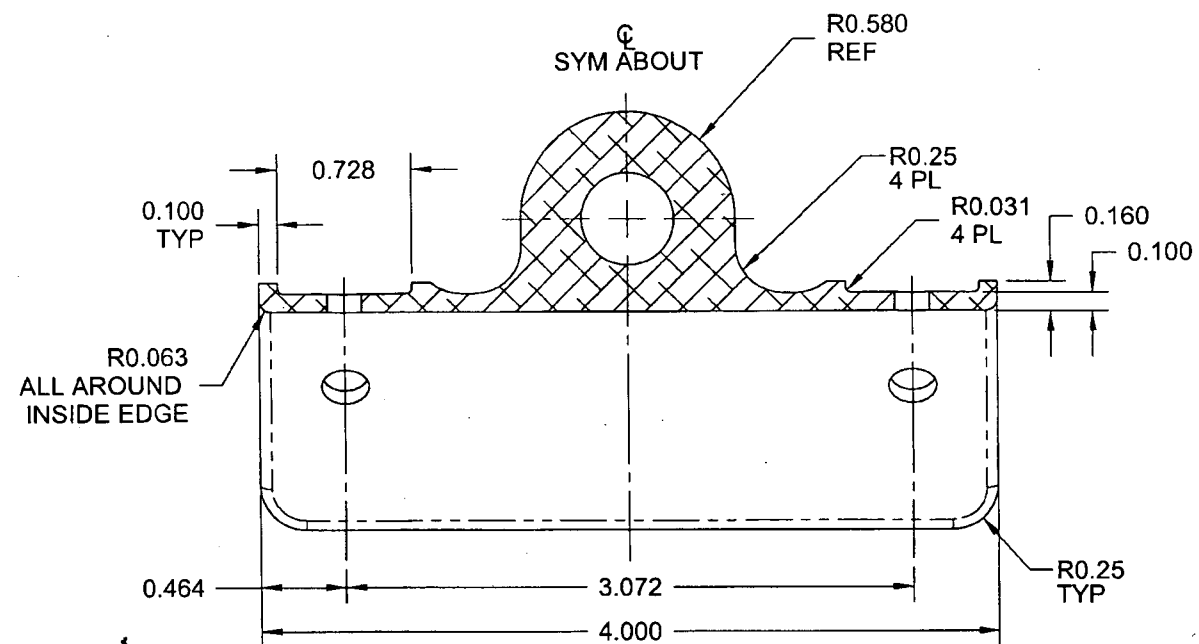
- 1) MATERIAL: 17-4 PH STAINLESS STEEL
HEAT TREAT TO H900 CONDITION
(900°F FOR 1 HR, AIR COOL)
MIN UTS = 170 KSI (38 HRc)
- 2) FINISH: PRIME INSIDE SURFACE AS SHOWN PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) 0.50" WIDE x 1.56" LONG x 0.005" MIN HEIGHT FLAT,
WITH R0.25 RADIUS OF TRANSITION IN THIS AREA
IDENTIFY WITH DART LOGO AND PART NUMBER ON ONE
SIDE AND DART LOGO AND BATCH NUMBER ON OPPOSITE
SIDE USING 0.010-0.020 DEEP LETTERING
- 7) WEIGHT: 0.98 lbs



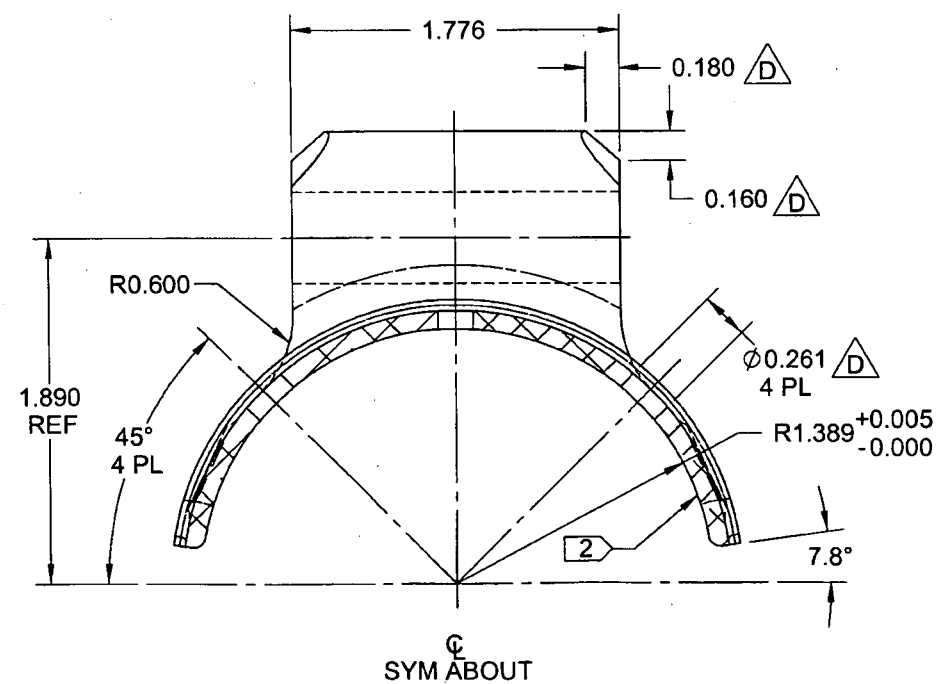
REV.	DESCRIPTION	BY	DATE
D	DRAWING REFORMATTED. POWDER COAT FINISH REMOVED. CHAMFERS ADDED TO TOP OF PART TO CLEAR ROCKER BEAM, PER BELL TECH BULLETIN 407-08-84. B5-2 0.261 HOLE WAS 0.257. B2-2 REAM FINISH INSTRUCTION ADDED.	AJS	08.11.06
C	ADD MASKING AND PRIME ONLY NOTES, REFORMATTED DRAWING.	DC	07.07.04
B	AS MANUFACTURED	CP	02.07.17
A	NEW ISSUE	CP	02.04.02
DESIGN	CP	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2894	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		Ø2.750 SUPPORT	NTS
DATE	08.11.06	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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08/11/19

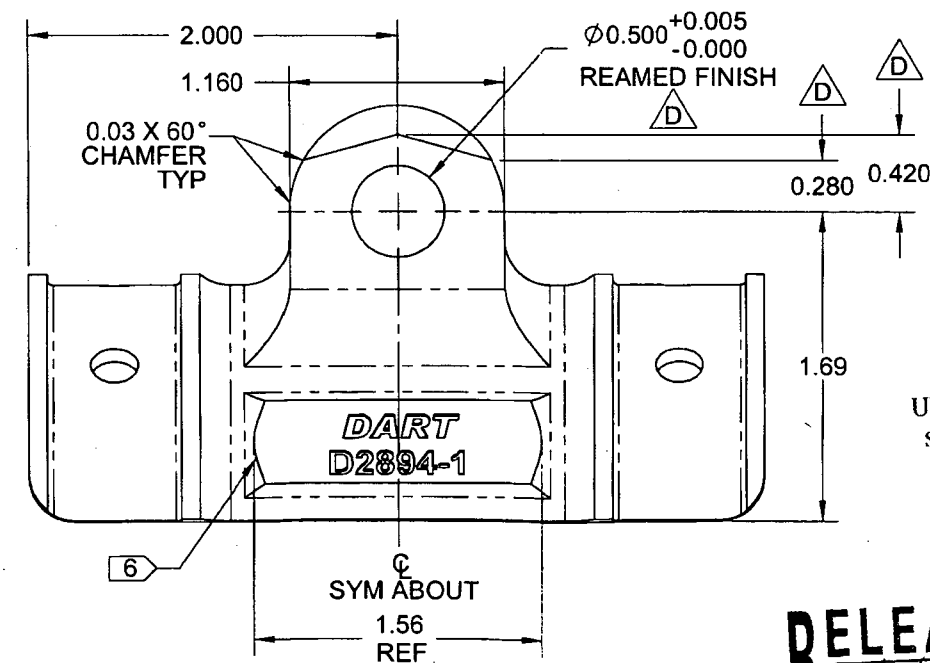
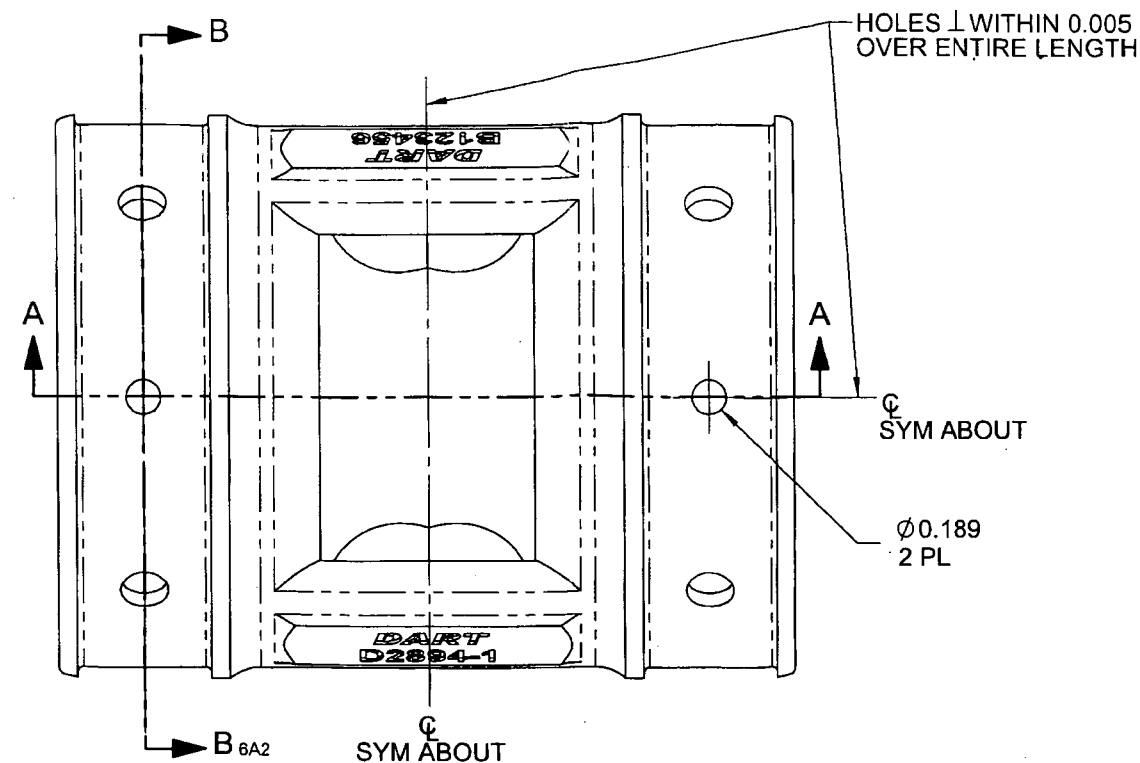
SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43881



SECTION A-A



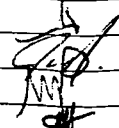
SECTION B-B C3-2
(VIEW ROTATED 90°)



D2894-1 Ø2.750 SUPPORT

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 4388

RELEASED
08/11/19

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2894	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		Ø2.750 SUPPORT	NTS
DATE	08.11.06	COPYRIGHT © 2002 BY DART AEROSPACE LTD	
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